



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

shp 12/04

D4640-15
Job Sheet 175478



Part No: D4640-15

Job Qty: 1 ea

Part Name: Ceiling Protector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 4/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 8,9 IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC IPP REV:B 12.10.17 AS PER REV.B VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/9/18	0.00	0.00	Start Up Waterjet		SC 18/04/18
100	Waterjet	1 pcs		4/10/18	0.00	0.28	Waterjet1		SC 18/04/18
110	QC	1 pcs		4/10/18	0.00	0.00	QC2		SC 18/04/18
120	QC	1 pcs		4/10/18	0.00	0.00	QC8		38
130	Packaging	1 pcs		4/10/18	0.00	0.00	Packaging3		9-89
140	QC21-SA	1 Ea		4/10/18	0.00	0.00	QC21		APR 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	16 sf (16 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MLEXS.093-F6006-07	16	2,079	0

Part Specifications

Specifications could not be found.

Plex 4/5/18 10:20 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐		
Date : _____	Step #: _____	MRB (QSI042) Approval _____ _____		
Completed By _____		Lead hand / Supervisor Approval Verification _____		
QC / QA Coordinator Approval _____		QC / QA Coordinator Approval _____		

Root Cause

Environment	☐	No
Design	☐	Opt
Doc/Data	☐	Offs
Equip/Tooling	☐	Supp
Handling/Pre	☐	Traini
Material	☐	Use fo
Internal Transport	☐	Poor Information
Tribal Knowledge	☐	Rushing
LOA	☐	Product Improvement
Substation	☐	Process Improvement
Past Expiry Date	☐	Manufacturing Process
Misidentified	☐	Past Due

Other

Broken/Damage/Defect	☐
Inspection Incomplete/Unqualified	☐
Contamination	☐
Countersink	☐
Cut Too Short	☐
Instructions Incomplete/Unclear	☐
Drill Holes	☐

Loss/Surge

Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

Other

Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

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 Hawkesbury, ON K6A 1K7
 CANADA
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 Email: sales@dartaero.com
 www.dartaero.com



Container No: S059574
 Part: D4640 - 15
 Job No: 175478
 Serial No/Batch: S059574
 Revision:
 Inspector:

Date: 04/10/18

DART AEROSPACE LTD		Work Order:	175 478
Description: Ceiling Protector		Part Number:	D4640-15
Inspection Dwg: D4640	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.80	1		VPC-01 Tape	
22.03	+/-0.030	22.03	1			
20.06	+/-0.030	20.06	1			
13.06	+/-0.030	13.06	1			
3.60	+/-0.030	3.60	1			
8.09	+/-0.030	8.09	1			
20.86	+/-0.030	20.86	1			
3.11	+/-0.030	3.11	1			
7.27	+/-0.030	7.27	1			
5.10	+/-0.030	5.10	1			
4.85	+/-0.030	4.85	1			
13.06	+/-0.030	13.06	1			
1.50	+/-0.030	1.50	1			
5.00	+/-0.030	5.00	1			
57.46	+/-0.030	57.46	1			
82.37	+/-0.030	82.37	1			
Ø8.13	+0.012/-0.001	Ø8.13	1			
6.77	+/-0.030	6.77	1			
5.72	+/-0.030	5.72	1			
6.13	+/-0.030	6.13	1			
2.21	+/-0.030	2.21	1			
0.88	+/-0.030	0.88	1			
7.78	+/-0.030	7.78	1			
7.47	+/-0.030	7.47	1			
Ø0.375	+0.006/-0.001	Ø0.380	1			
9.73	+/-0.030	9.73	1			
21.00	+/-0.030	21.00	1			
31.28	+/-0.030	31.28	1			
4.00	+/-0.030	4.00	1			
27.23	+/-0.030	27.23	1			
22.28	+/-0.030	22.28	1			
20.36	+/-0.030	20.36	1			
0.093	+/-0.010	0.093	1			

Measured by: SC	Audited by: 38	Preliminary Approval:
Date: 18/04/10	Date: APR 10 2018	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Linda Lacelle

From: Kinga Lysiak
Sent: Monday, April 9, 2018 7:32 AM
To: Linda Lacelle
Subject: RE: Order 4806

Hi Linda

Untrimmed please

Best regards,
Kinga Lysiak
Inside Sales Representative
EMEA, Russia & CIS



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1 Bell Street, G01
Maidenhead
Berkshire, UK
SL6 1BU
M +44 (0) 7828775275
E klysiak@dartaero.com
www.dartaerospace.com

From: Linda Lacelle
Sent: Friday, April 6, 2018 5:38 PM
To: Kinga Lysiak <klysiak@dartaero.com>
Subject: RE: Order 4806

Kingaaaaaaaaaaaa

We need to know if the D4640-15 is trimmed or untrimmed plsssssssss

See attached where the lines are on the -15, and Note 9 on first page

Thx

L

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OTHER : _____					